5/08

DART AEROSPACE LTD		Work Order:	22320
Description: 206 L/L-1/L-3/L-4 HighGear Web 04.08.17 ❦ 04.08.17 ❦		Part Number:	D2654-7
Drawing: D2654 Rev. ~~D E~~ E1		Qty:	2

Step	Location	Procedure	By	Date	QTY
1	EXPEDITING	Issue Work Order	❦	05.01.26	2
2	METAL	Pick: Qty Part Number Description Batch 1 D2600-7 Web B-21130	BE	05-03-02	2
3	METAL	Cut D2600-7 to length as per Dwg D2654 ~~(116.00") DM 97.08.19 RF 04.07.07~~	BE	05-03-06	2
4	METAL	Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654	BE	05-03-03	2
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654	BE	05-03-03	2
6	METAL	Deburr holes and ends	BE	05-03-03	2
7	METAL	Acid Etch and Alodine as per QSI 005 4.1	BE	05-03-04	2
8	QC	Inspect Level 5	❦	05-03-07	2
9	METAL	Identify and stock	❦	05-3-8	2
10	EXPEDITING	Close Work Order Cost/part: 51.61 S4C 05/03/09 (2) 51.61	❦	05.03.10	2

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	❦

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9- 89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

RELEASED
DM99.0219

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Mfg / Design Mgr	**Approval** QC Inspector

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action	Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Design Mgr	**Action Description** Design Mgr	**Sign & Date**	**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
		PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.		REV. E
		D2654		SHEET 1 OF 2
DATE		TITLE		SCALE
04.05.26		WEB		1:20

A	97.03.25	NEW ISSUE
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438
C	97.10.29	CHANGED HOLE PATTERN
D	98.01.15	GHW HOLES CHANGED TO ⌀0.63
E	04.05.26	CHANGE LENGTHS, REFORMAT
E1	04.08.04	PER TOOLING; 80.8 WAS 80.5
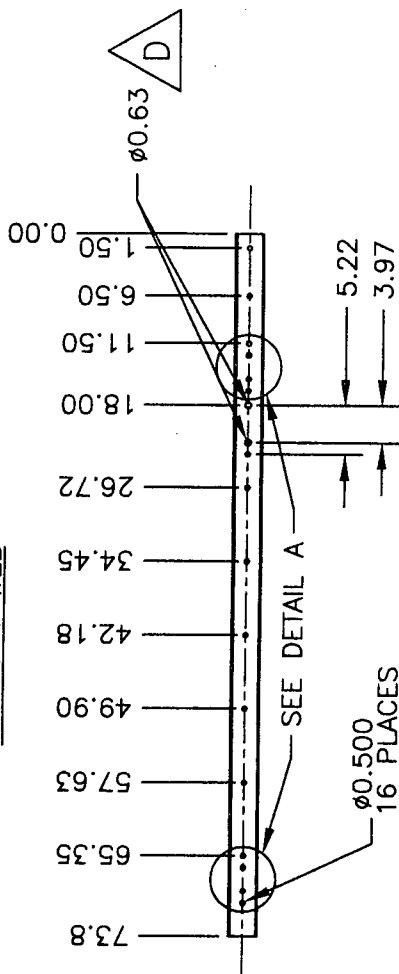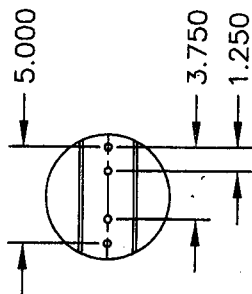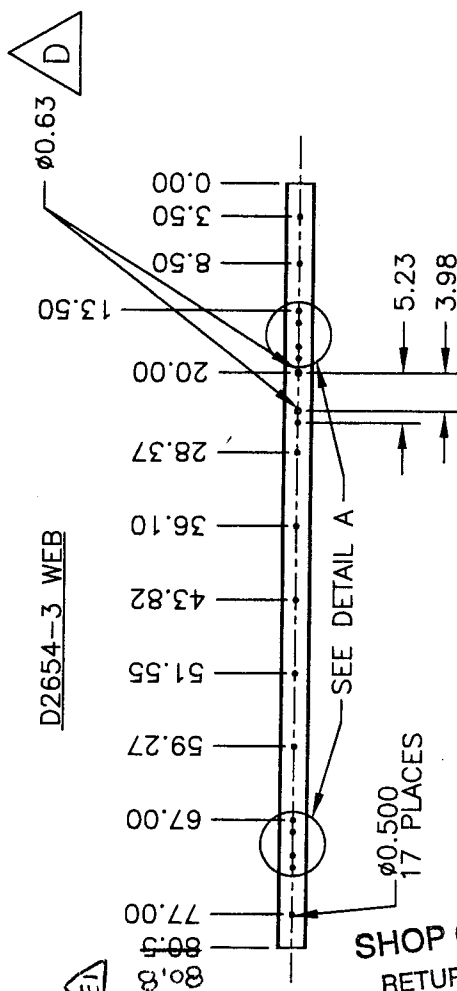
D2654-1 WEB

⌀0.63 △D

0.00
1.50
6.50
11.50
18.00
26.72
34.45
42.18
49.90
57.63
65.35
73.8

5.22
3.97

SEE DETAIL A

⌀0.500
16 PLACES

D2654-3 WEB

⌀0.63 △D

0.00
3.50
8.50
13.50
20.00
28.37
36.10
43.82
51.55
59.27
67.00
77.00
80.8
△E1

5.23
3.98

SEE DETAIL A

⌀0.500
17 PLACES

DETAIL A
SCALE 1:10

5.000
3.750
1.250

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

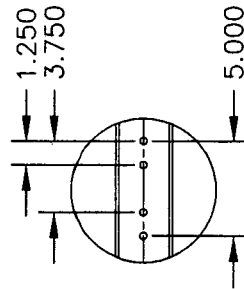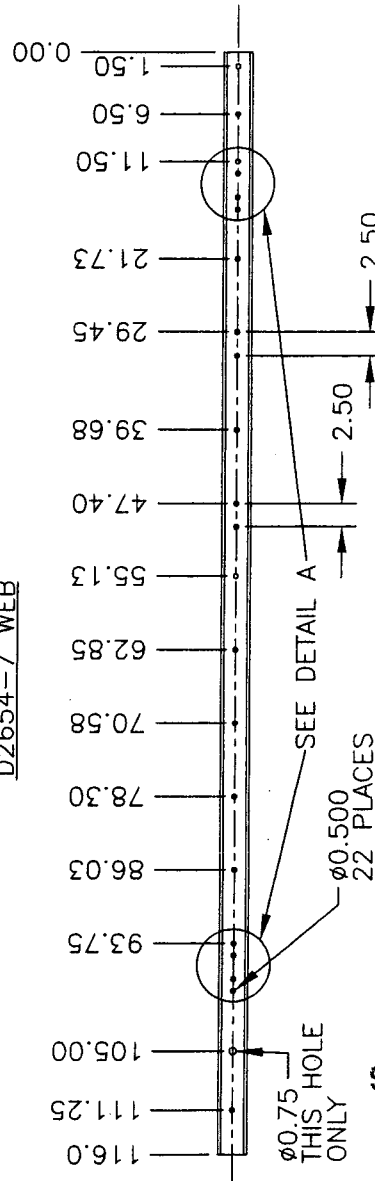| DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2654	SHEET 2 OF 2
DATE		TITLE	SCALE
04.05.26		WEB	1:20

QA COPY ISSUED

RELEASED
04.06.22

DETAIL A
SCALE 1:10

1.250
3.750
5.000

D2654-5 WEB

0.00
4.00
14.22
21.95
32.17
39.90
47.62
55.35
70.80
78.52
86.25
94.7

2.50
2.50

SEE DETAIL A

⌀0.500
19 PLACES

D2654-7 WEB

0.00
6.50
11.50
21.73
29.45
39.68
47.40
55.13
62.85
70.58
78.30
86.03
93.75
105.00
111.25
116.0

1.50

2.50

2.50

SEE DETAIL A

⌀0.500
22 PLACES

⌀0.75
THIS HOLE
ONLY
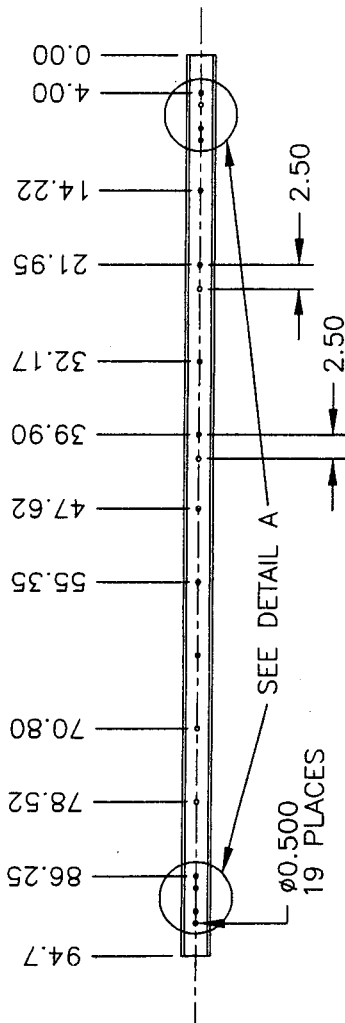
MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
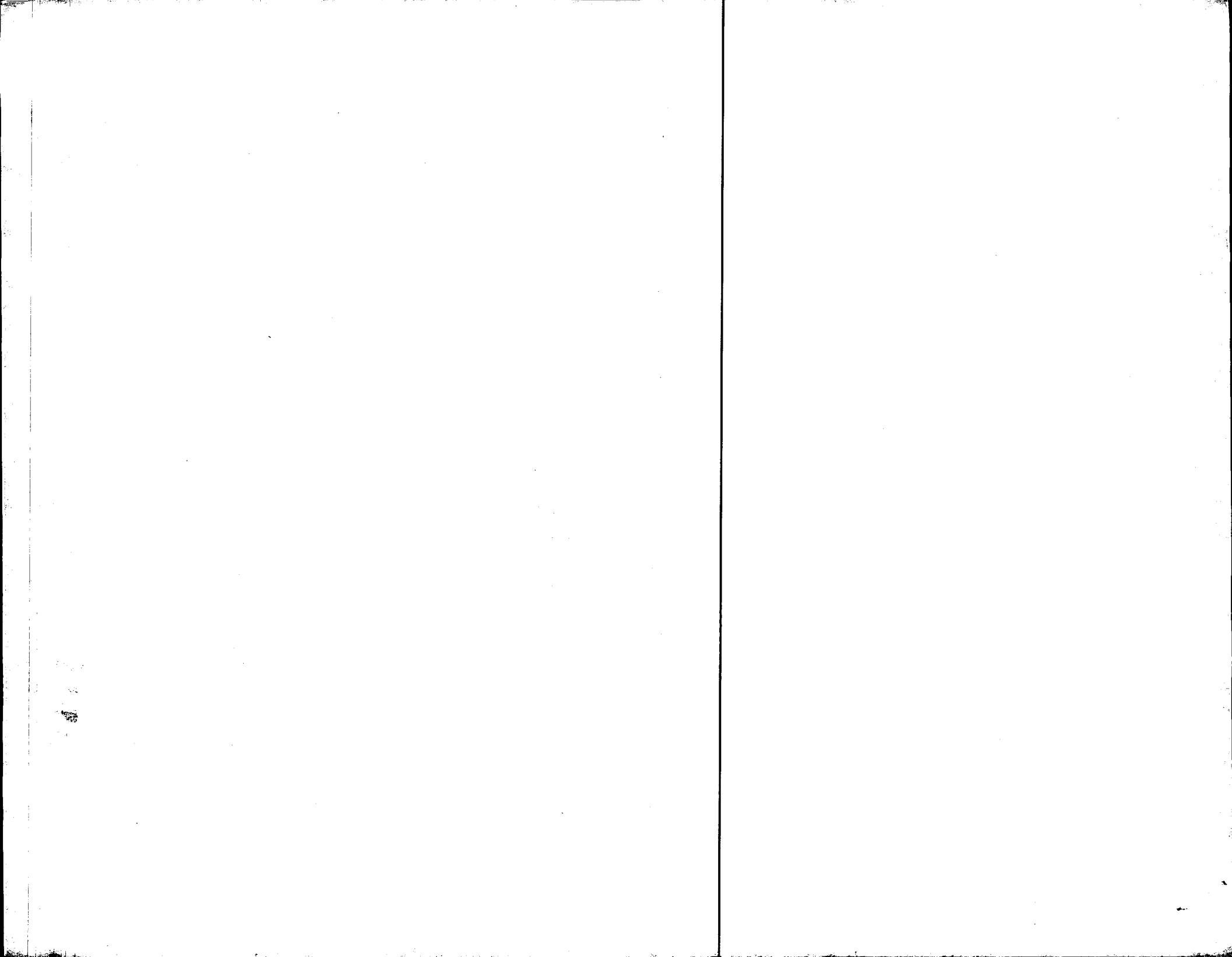TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd.   Jan 25, 2005
Hawkesbury   03:20 pm

Work Order No	: 0022320	
Project Name	: D2654-7	Department Code:
Project For	: WK508	Burden Flags : NNNNNNN
Work Order Type	: Main	WO Status : Open
Main WO Number	:	Invoice State : Not Invoiced
House Part Number	: D2654-7	Invoice Date :
Description	: 206 I Beam (Web)	Invoice Number :
Manufactured	: Yes	Invoice Amount : 0.00
Amount Req'd	: *2*	
Amount Done	: 0	Order Entry No :
Start Date	: 01-25-05	OE Value : 0.00
Est Finish Date	: 02-28-05	
Act Finish Date	:	Est Margin : 0.000%
Drawings Reqd	: No	Actual Margin : 0.000%
Ok for Approval	:	
Approval Rec'd	:	$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
	==========	==========	=======		
Burden	: 0.00	0.00	0.00		
	==========	==========	=======		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00